

Date: Tuesday, 12/20/2005 3:21:01 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SPACEPOD BODY RH		
Job Number	: 25302A					
Estimate Number	: 11102					
P.O. Number	: N/A			Part Number	: D31882	
This Issue	: 12/20/2005 S.O. No. : N/A			Drawing Number	: D3186 REV A	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: 12/20/2005 Type : SMALL /MED FAB			Drawing Revision	: A	
Previous Run	: 25301A			Material	: N/A	
Written By	: See COMMENT Below			Due Date	: 1/20/2006	
Checked & Approved By	: See ABOVE USER & DATE			Qty:	1 Um: Each	
Comment	: Est Rev:A New Issue 05-11-29 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2213	Aluminum Spacer	
		Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s) Ship To Delastek	
8	D2213	Spacer	Batch: <u>B22997A</u> 1 05.12.21 JL (1)
2.0	PG	PURCHASING	
		Comment: PURCHASING Issue P/O: <u>00000324</u> <u>01/12/21</u> Description: D3188-2 BODY SHIP LABEL D0600-142 & D2213 Spacers Supplier: Delastek Conformity Certificate and Process sheet required Ship 2 Items from Previous steps	(1)
3.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.	<u>C66103128</u> (1)
4.0	QC6	DIMENSIONAL CHECK	
		Comment: DIMENSIONAL CHECK Inspect dimensions as per Dwg D3188. Visual inspection. Check for void spot and pins.	<u>16-04-04</u> (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/04/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/04/05	3	Tool body does not ^{Fig (Delastek)} doesn't conform with the dwg.	<u>RD</u> <u>04/04</u>	Body is good. dwg to be under review by engineering. In new hole dimensions. Engineering notified.	<u>RD</u> <u>04/04</u>	<u>RD</u> <u>04/04</u>	<u>RD</u> <u>04/04</u>	<u>RD</u> <u>04/04</u>
				Also see NCR 032				

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD BODY RH

Job Number: 25302A

Part Number: D31882

Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	PACKAGING 1	PACKAGING RESOURCE #1 (1)
Comment:	PACKAGING RESOURCE #1 Identify and Stock Location: CA	
6.0	DC	DOCUMENT CONTROL (1)
Comment:	DOCUMENT CONTROL Inspection Level 21	

Job Completion



(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN JB	DRAWN BY <i>JP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>AS</i>	APPROVED <i>CD</i>	DRAWING NO. D3188	REV. A SHEET 1 OF 7
DATE 03.04.03		TITLE SPACEPOD BODY	SCALE NTS
A	03.04.03	NEW ISSUE	

RELEASED
03.04.22

GENERAL NOTES:

1. REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
2. LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
3. MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINCELL
OR AIREX
OR KLEGECCELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

4. MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1	DT8003	DT8501
D3188-2	DT8004	DT8502
D3188-3	DT8500	DT8501

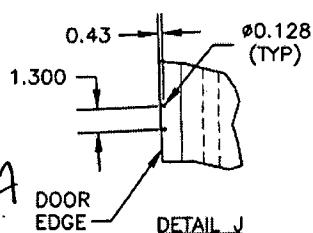
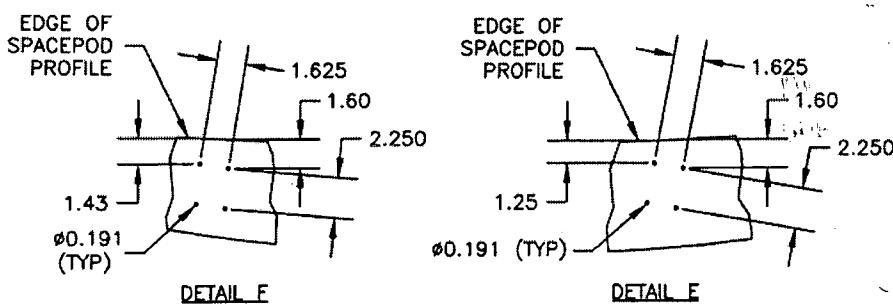
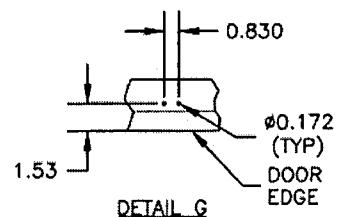
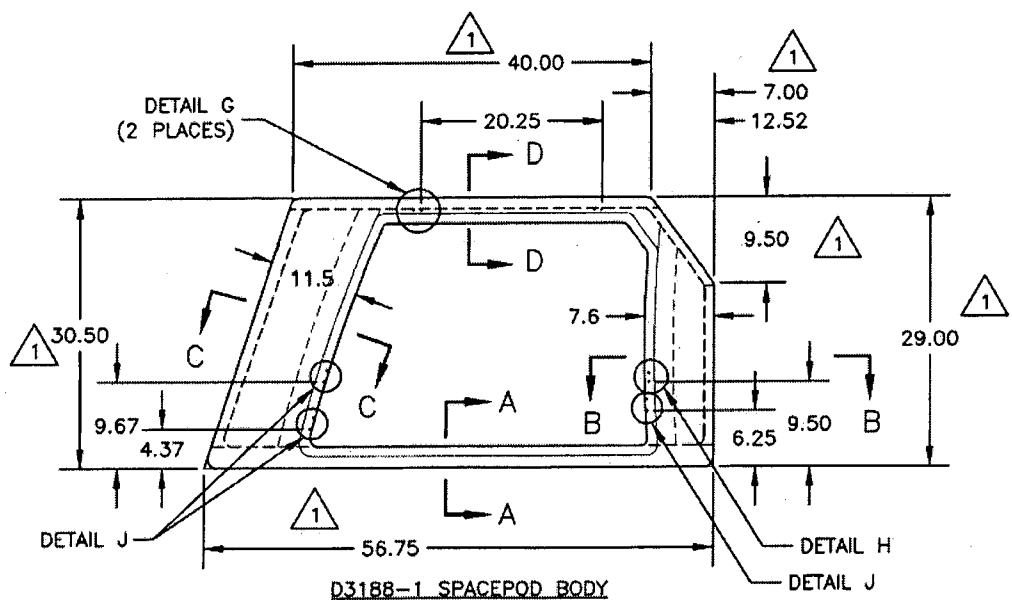
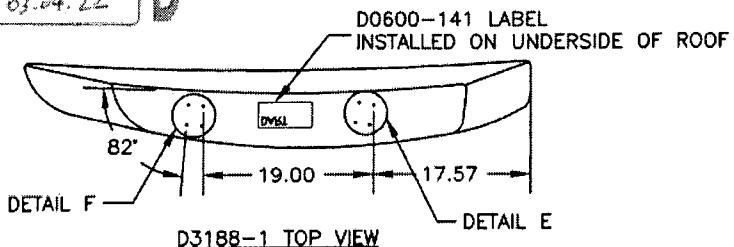
5. APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
6. FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S

NON-COPY
NO COPY
NO COPY
COPY
COPY

25302 A

DART

DESIGN	JB	DRAWN BY	DART AEROSPACE LTD	
CHECKED		APPROVED	HAWKESBURY, ONTARIO, CANADA	
DATE			DRAWING NO.	REV. A
	03.04.03		D3188	SHEET 2 OF 7
			TITLE	SCALE
			SPACEPOD BODY	NTS

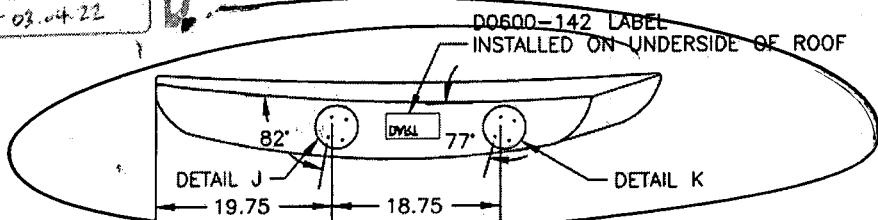
04
COPIED
10/03/03**RELEASED**
03.04.22

DARTQ4
2003
ISSUED

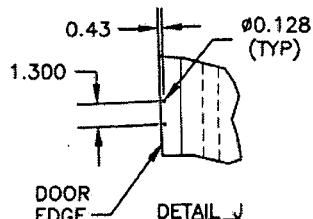
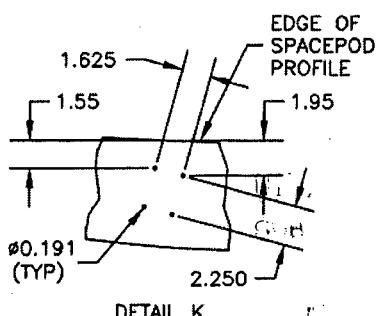
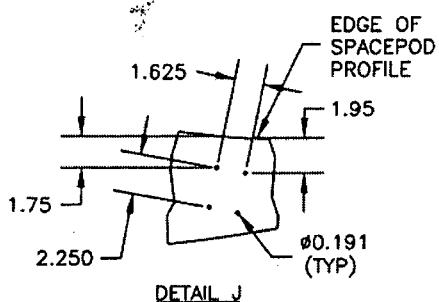
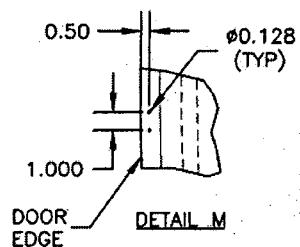
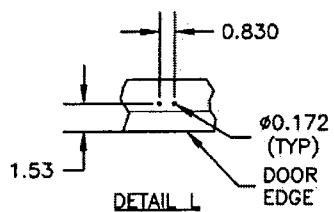
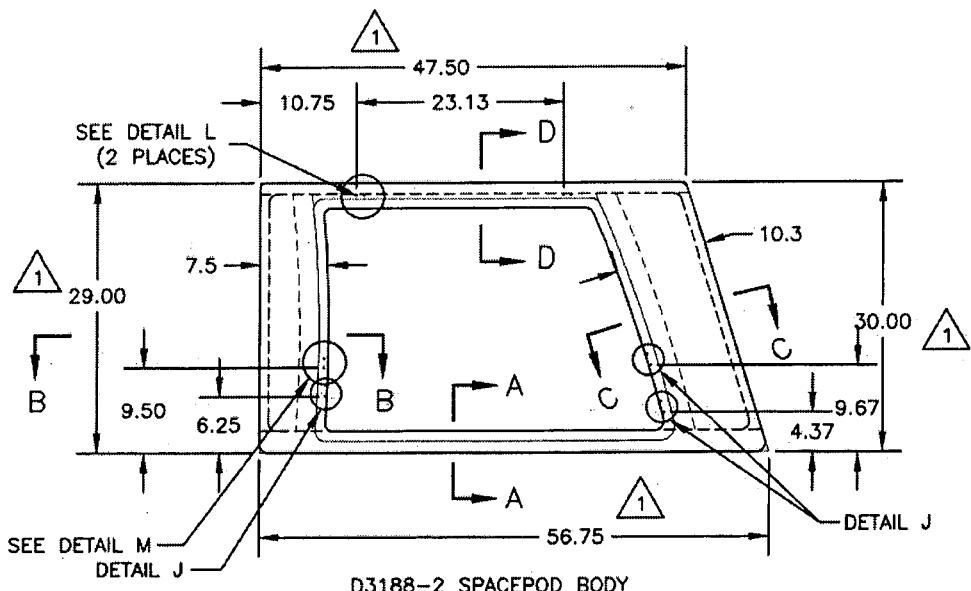
DESIGN JB	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
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DATE 03.04.03		SHEET 3 OF 7

RELEASED

03.04.22



D3188-2 TOP VIEW



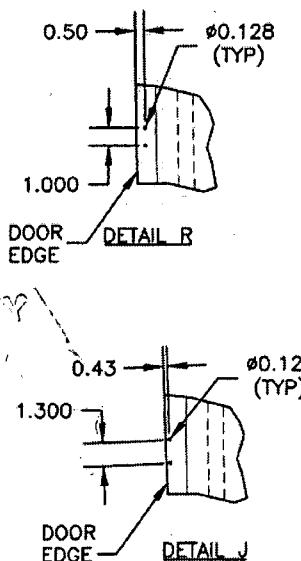
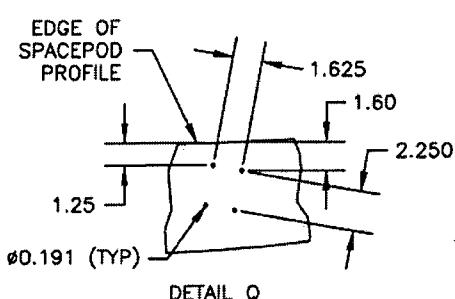
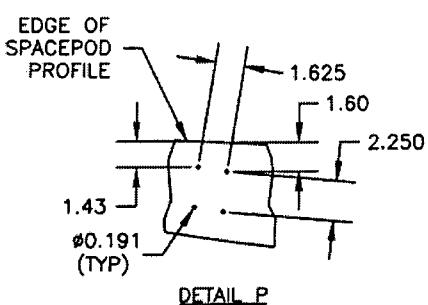
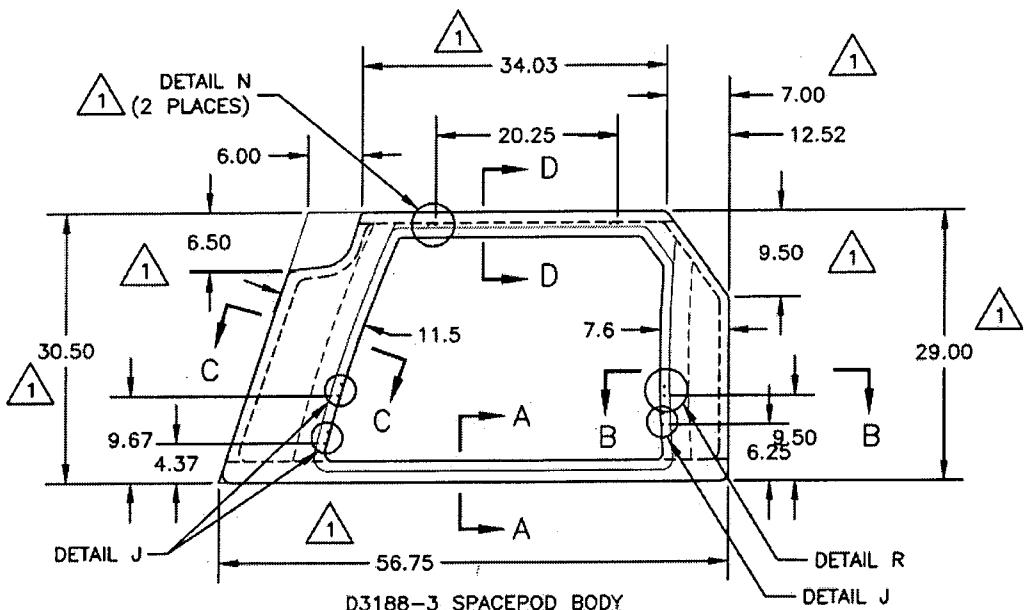
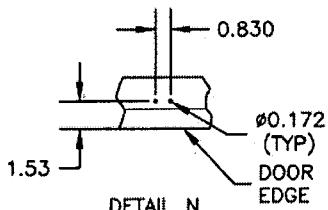
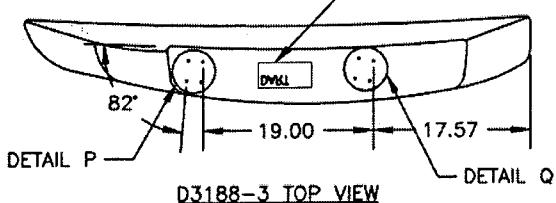
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CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3188	REV. A SHEET 4 OF 7
DATE 03.04.03		TITLE SPACEPOD BODY	SCALE NTS

QC
ISSUED**RELEASED**
03.04.22D0600-143 LABEL
INSTALLED ON UNDERSIDE OF ROOF

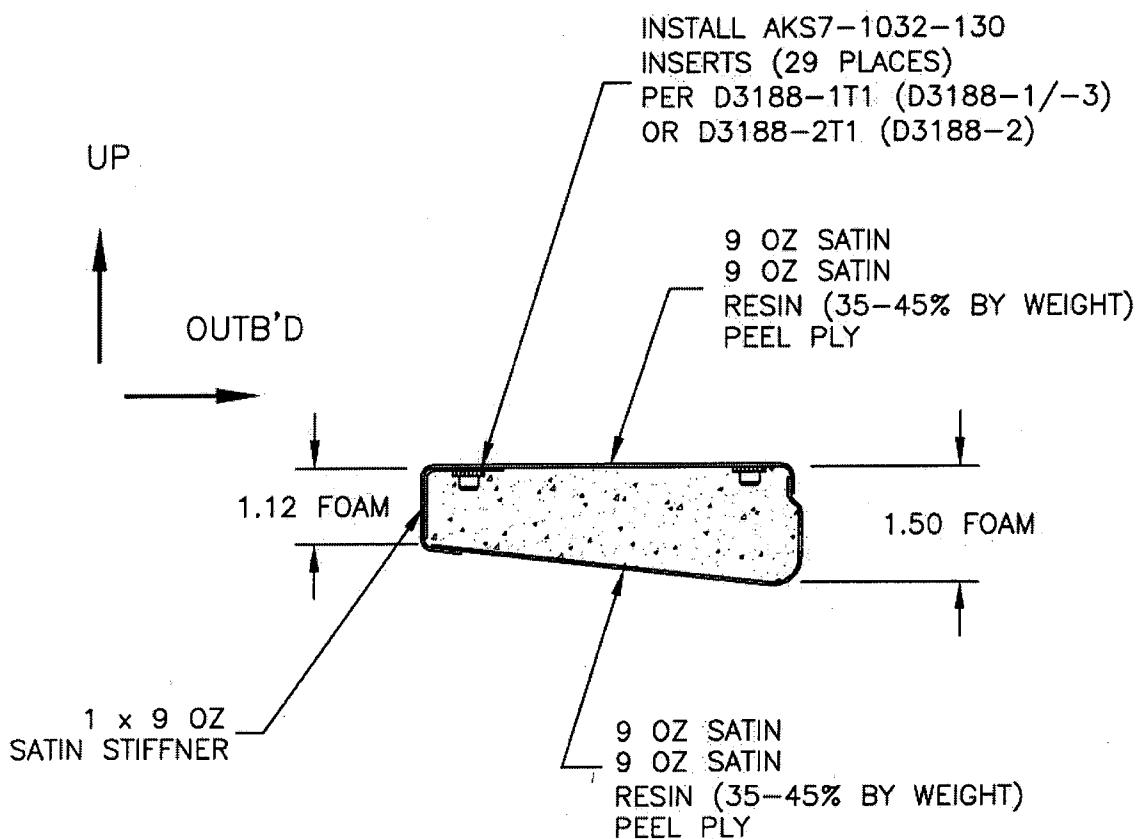
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DATE 03.04.03		REV. A SHEET 5 OF 7 TITLE SPACEPOD BODY SCALE NTS

RELEASED
03.04.03

SECTION A-A
(TYPICAL FLOOR SECTION)

25302A

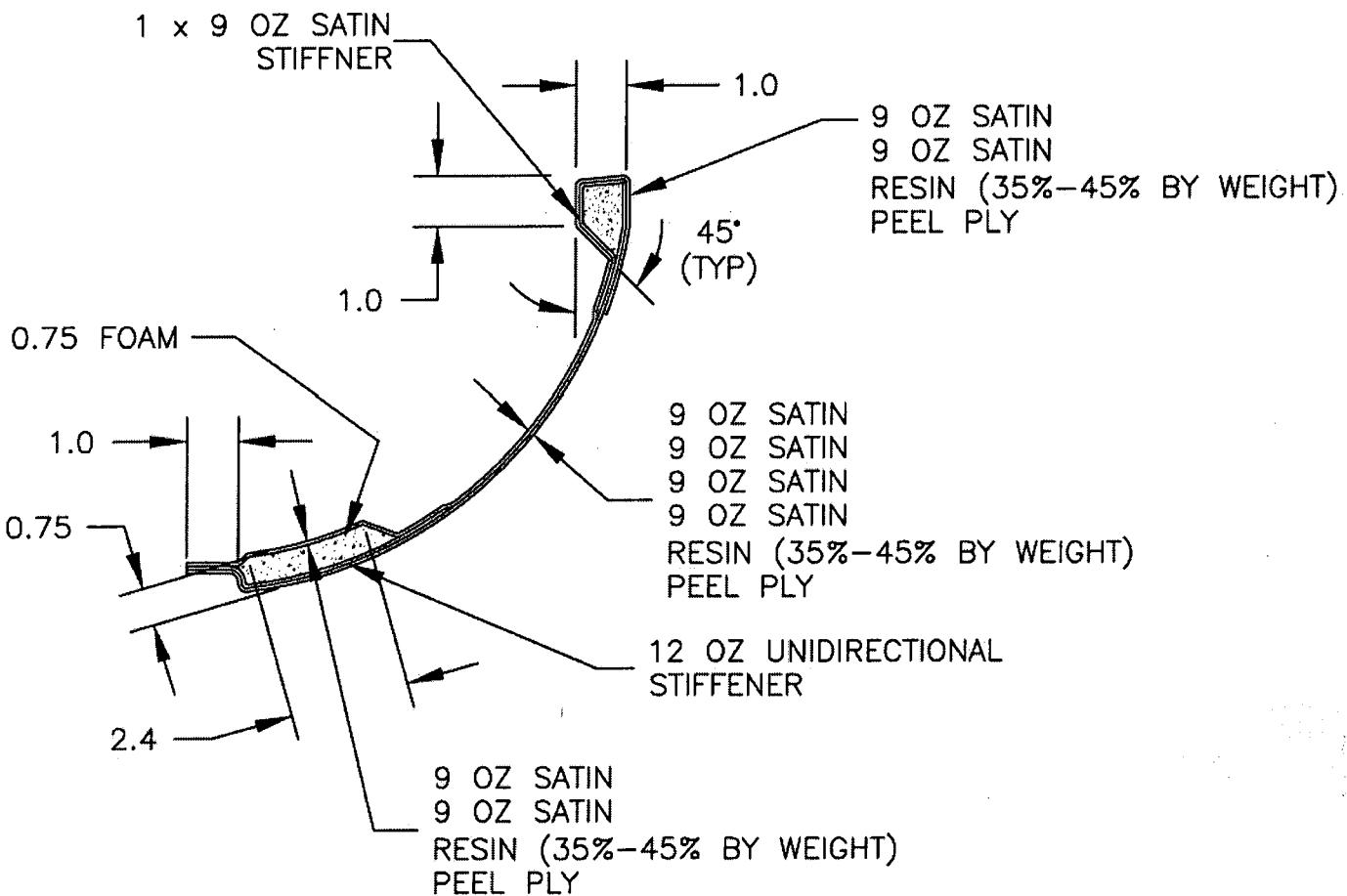
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3188 REV. A SHEET 6 OF 7
DATE 03.04.03		TITLE SPACEPOD BODY SCALE NTS

03.04.29 *[Signature]*
RELEASE



SECTION B-B
(SECTION C-C SIMILAR)

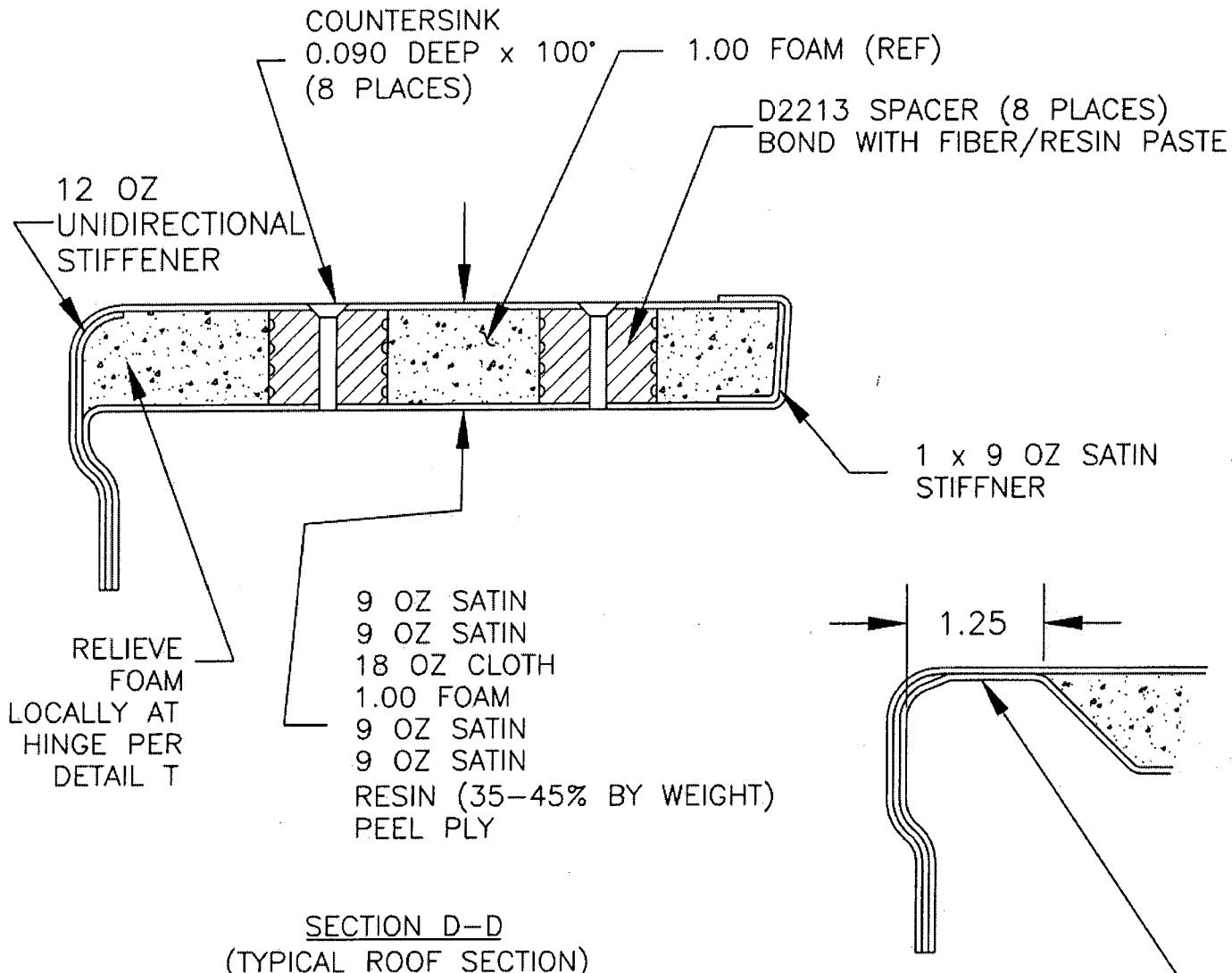
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CHECKED <i>#</i>	APPROVED <i>C</i>	DRAWING NO. D3188	REV. A SHEET 7 OF 7
DATE 03.04.03		TITLE SPACEPOD BODY	SCALE NTS

**RELEASED**
03.04.03

SECTION D-D
(TYPICAL ROOF SECTION)

RELIEVE AS SHOWN
3" LONG CENTERED
ON HINGE

DETAIL T

W
NC 25302A

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Linda Lacelle

From: Linda Lacelle [llacelle@dartaero.com]
Sent: Tuesday, March 28, 2006 2:24 PM
To: 'Jocelyne Laurin'
Cc: 'shamel@delastek.com'
Subject: RE: RE : SHIPMENT FROM YESTERDAY

ok...here's the scoop:

-for P.O 324 we will use B/N 25300 for the door we received, you will have to supply us the body with the same B/N 25300
-for the D3188-2/86-2 we will use B/N 25302 - the one left to deliver on this P.O 324 - you will have to supply us with the B.N 25301
- for P.O 610 you can only use the B/N's issued on the P.O 25851 and 25852

Thx

Linda

-----Original Message-----

From: Jocelyne Laurin [mailto:jlaurin@delastek.com]
Sent: Tuesday, March 28, 2006 8:56 AM
To: 'Linda Lacelle'
Cc: shamel@delastek.com
Subject: RE : SHIPMENT FROM YESTERDAY

Bonjour Linda,

For p.o. #324 D3186-1, can you please use label #B25851, since the spacepod body LH will have the label #B25851.

As for D3188-2 / D3186-2 - with label 24307, you can use either B26064, B26065 or B25302. Please advise which one you will use.

>From now on, we will mark our W/O and our B/N on the packing slips.

Please note that on your order #610, for the second set of spacepod door and Body LH, we will use label #B25300, since we already used the label #B25851 on po #324.

Thanks and have a nice day.

Jocelyne Laurin
Service à la Clientèle/Customer Service
Tel: 1-819-533-5788 p. 221
Fax: 1-819-533-3494

-----Message d'origine-----

De : Linda Lacelle [mailto:llacelle@dartaero.com]
Envoyé : March 24, 2006 9:18 AM
À : Jocelyne Laurin (E-mail); Mgodin@Delastek.Com (E-mail);
Sheroux@Delastek.Com (E-mail)
Cc : Jason Murdoch (E-mail)
Objet : SHIPMENT FROM YESTERDAY
Importance : Haute

we received a few items yesterday, but were all mixed up...p.o 324 D3186-1 - has a label of 21558 - this is a very old batch, and had been completed in Oct, 2005. There is no w/o marked on your packing slip or invoice...we need to know what labels you have left, so we can figure out what w/o here to attach it to.
D3188-2 / D3186-2 - has a label of 24307 - was completed in Nov., 2005, again no w/o to match from your packing slip, and again need to know what

labels you have left at Delastek, so we can assign the correct internal batch and w/o to it.

D350-604-041...we require you to mark your w/o and our B/N on the packing slips, in order to match the correct process sheets

D206-605-041 ...we require you to mark your w/o and our B/N on the packing slips, in order to attach the correct process sheets.

Please advise asap.

Thanks

Linda

